






Work Order ID 61332



August 18, 2010 11:28:00 AM



Page 1

Item ID: D2571 Accept  Setup Start 
 Revision ID: Stop 
 Item Name: Saddle, Fwd Out 205
 Start Date: 8/18/10 Start Qty: 12.00  Cust Item ID:
 Required Date: 9/07/10 Req'd Qty: 12.00  Customer:


Reference:

Approvals: Process Plan: CL Date: 10/8/18 Tooling: _____ Date: _____ Run Start 
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2571 | Rev E |

| | | | | | | | | | |
|-----|--------------------------------|------|--|--|--|----|---|--|--|
| 100 | HAAS CNC VERTICAL MACHINING #1 | 0.00 | | | | 12 | Ø | | |
|-----|--------------------------------|------|--|--|--|----|---|--|--|

HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 Program Batch No. 61332 Double check by: ☐ 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets ☐ 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets ☐ 3-Machine Step No 3 per Folio FA051 and inspect  10/09/04

| | | | | | | | | | |
|-----|------------------------------|------|--|--|--|----|---|--|--|
| 110 | CONVENTIONAL MILLING MACHINE | 0.00 | | | | 12 | Ø | | |
|-----|------------------------------|------|--|--|--|----|---|--|--|

Mill Conv Memo 0.00
 Conventional Milling Machine Machine keyway as per dwg D2571 & D2572  10/09/05

| | | | | | | | | | |
|-----|---|------|--|--|--|----|---|--|--|
| 120 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | 12 | Ø | | |
|-----|---|------|--|--|--|----|---|--|--|

QC Memo 0.00
 Quality Control  10/09/05

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 61332

August 18, 2010 11:28:00 AM



Page 2

| | | | | | |
|--------------------------------|------------------|--|---------------|-------|--|
| Item ID: D2571 | Accept | | Setup | Start | |
| Revision ID: | | | | Stop | |
| Item Name: Saddle, Fwd Out 205 | | | | | |
| Start Date: 8/18/10 | Start Qty: 12.00 | | Cust Item ID: | | |
| Required Date: 9/07/10 | Req'd Qty: 12.00 | | Customer: | | |
| Reference: | | | | | |

| | | | | | | | |
|------------|---------------------|-------------|------------------|-------------|-----|-------|--|
| Approvals: | Process Plan: _____ | Date: _____ | Tooling: _____ | Date: _____ | Run | Start | |
| | QC: _____ | Date: _____ | SPC (Y/N): _____ | Date: _____ | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|--------------|--------------|---------------|---------------|------------------|----------------|
| 130 QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | SP 10/09/15 | | 12 | Ø | | |
| 140 HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | ⇒ M 10/09/16 | | 12 | Ø | | |
| 150 Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 115291 Memo START TIME: 8:10 3200 □ FINISH TIME: 8:40 | 0.00 0.00 | | BL 10-9-21 | | 12 | Ø | | |

□ OVEN TEMPERATURE:

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 61332

August 18, 2010 11:28:00 AM



Page 3

Item ID: D2571

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 8/18/10

Start Qty: 12.00



Cust Item ID:

Required Date: 9/07/10

Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

160

QC3- Inspect Part Finish

0.00

M 10/09/21

12

0

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 433

0.00

Packaging

Memo

0.00

Packaging

10/9/22 RDS

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/09/23 mf 10-9-22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

August 18, 2010 11:28:00 AM

Page 1

Work Order ID: 61332



Parent Item: D2571



Parent Item Name: Saddle, Fwd Out 205

Start Date: 8/18/10

Required Date: 9/07/10

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I□02.10.02□Re-format; Change to Dwg Rev. D & incorporated
D2572□KJ□

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6101-007 Saddle Billet | | Manufactured | No | | | 100 | Each | 38.0000 | 1 | 12 | | | |

Location

Loc Qty

Loc Code

MAT42

38

40412

2

✓60314

36

12 ISIP 10/09/04

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|--|---------------------|-------------|
| DART AEROSPACE LTD | Work Order: | 61332 |
| Description: Saddle, Fwd Outboard | Part Number: | D2571 |
| Inspection Dwg: D2571 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|--------|--------|--------|---------|----------|
| | | | | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | | 0.442 | 0.442 | 0.442 | 0.442 | DTP-11 | Vern |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | " |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | | " |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | " |
| E | 7.990 | 8.010 | | 8.004 | 8.003 | 8.000 | 8.000 | CWK-02 | Vern |
| F | 0.490 | 0.510 | | 0.498 | 0.494 | 0.490 | 0.492 | DTP-11 | Vern |
| G | 0.257 | 0.262 | | 0.259 | 0.259 | 0.259 | 0.259 | | " |
| H | 0.375 | 0.380 | | 0.378 | 0.378 | 0.378 | 0.378 | | " |
| I | 0.490 | 0.510 | | 0.497 | 0.493 | 0.498 | 0.499 | | " |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | " |
| K | 0.558 | 0.578 | | 0.564 | 0.560 | 0.564 | 0.565 | | " |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | " |
| M | 1.490 | 1.500 | | 1.495 | 1.495 | 1.495 | 1.498 | | " |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | " |
| O | 3.869 | 3.879 | | 3.874 | 3.874 | 3.874 | 3.874 | | " |
| P | 0.115 | 0.135 | | 0.124 | 0.125 | 0.124 | 0.1255 | DTP-02 | Micro |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | DTP-11 | Vern |
| R | 0.240 | 0.260 | | 0.253 | 0.253 | 0.252 | 0.253 | DTP-02 | Micro |
| S | 0.115 | 0.135 | | 0.135 | 0.132 | 0.132 | 0.132 | 118-120 | Deep Mic |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | Rad Gage |
| U | 2.940 | 2.980 | | 2.957 | 2.957 | 2.960 | 2.960 | DTP-11 | Vern |
| V | 0.230 | 0.250 | | 0.236 | 0.233 | 0.234 | 0.232 | | " |
| W | 0.115 | 0.135 | | 0.127 | 0.126 | 0.125 | 0.125 | 118-120 | Deep Mic |
| X | 0.308 | 0.313 | | 0.311 | 0.311 | 0.311 | 0.311 | DTP-02 | Micro |
| Y | 0.760 | 0.765 | | 0.762 | 0.762 | 0.762 | 0.762 | DTP-11 | Vern |
| Z | 0.352 | 0.372 | | 0.369 | 0.362 | 0.361 | 0.361 | | " |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | Rad Gage |
| AB | 0.615 | 0.635 | | 0.624 | 0.624 | 0.624 | 0.627 | DTP-11 | Vern |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | Rad Gage |
| AD | 0.240 | 0.260 | | 0.250 | 0.250 | 0.250 | 0.248 | DTP-11 | Vern |
| AE | 1.375 | 1.395 | | 1.389 | 1.3925 | 1.3925 | 1.394 | | Dial |
| AF | 0.115 | 0.135 | | 0.125 | 0.125 | 0.125 | 0.125 | DTP-11 | Vern |
| AG | 0.240 | 0.280 | | 0.260 | 0.260 | 0.260 | 0.260 | | " |
| AH | 0.240 | 0.260 | | 0.246 | 0.243 | 0.244 | 0.2435 | | " |
| AI | 2.000 | 2.020 | | 2.004 | 2.0035 | 2.002 | 2.004 | | Dial |
| AJ | 0.023 | 0.043 | | 0.033 | 0.033 | 0.033 | 0.033 | DTP-11 | Vern |
| Accept/Reject | | | | | | | | | |

| | |
|--------------|----------|
| Measured by: | DTP |
| Date: | 10/09/15 |

| | |
|-------------|----------|
| Audited by: | ST |
| Date: | 10/09/15 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

| | | |
|--|---------------------|-------------|
| DART AEROSPACE LTD | Work Order: | 61332 |
| Description: Saddle, Fwd Outboard | Part Number: | D2571 |
| Inspection Dwg: D2571 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|--------|--------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 5 | 6 | 7 | 8 | | |
| A | 0.438 | 0.443 | | 0.442 | 0.442 | 0.442 | 0.442 | | |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| E | 7.990 | 8.010 | | 8.000 | 8.000 | 8.000 | 8.000 | | |
| F | 0.490 | 0.510 | | 0.495 | 0.498 | 0.500 | 0.496 | | |
| G | 0.257 | 0.262 | | 0.259 | 0.259 | 0.259 | 0.259 | | |
| H | 0.375 | 0.380 | | 0.378 | 0.378 | 0.378 | 0.378 | | |
| I | 0.490 | 0.510 | | 0.498 | 0.495 | 0.498 | 0.498 | | |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| K | 0.558 | 0.578 | | 0.563 | 0.560 | 0.563 | 0.563 | | |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| M | 1.490 | 1.500 | | 1.495 | 1.495 | 1.495 | 1.495 | | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| O | 3.869 | 3.879 | | 3.874 | 3.874 | 3.874 | 3.874 | | |
| P | 0.115 | 0.135 | | 0.124 | 0.124 | 0.124 | 0.124 | | |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| R | 0.240 | 0.260 | | 0.252 | 0.252 | 0.252 | 0.252 | | |
| S | 0.115 | 0.135 | | 0.132 | 0.132 | 0.132 | 0.132 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| U | 2.940 | 2.980 | | 2.960 | 2.960 | 2.960 | 2.960 | | |
| V | 0.230 | 0.250 | | 0.233 | 0.233 | 0.234 | 0.234 | | |
| W | 0.115 | 0.135 | | 0.125 | 0.125 | 0.127 | 0.124 | | |
| X | 0.308 | 0.313 | | 0.311 | 0.311 | 0.311 | 0.311 | | |
| Y | 0.760 | 0.765 | | 0.762 | 0.762 | 0.762 | 0.762 | | |
| Z | 0.352 | 0.372 | | 0.363 | 0.362 | 0.363 | 0.363 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.629 | 0.627 | 0.627 | 0.627 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AD | 0.240 | 0.260 | | 0.250 | 0.252 | 0.252 | 0.252 | | |
| AE | 1.375 | 1.395 | | 1.3925 | 1.392 | 1.391 | 1.392 | | |
| AF | 0.115 | 0.135 | | 0.125 | 0.125 | 0.125 | 0.125 | | |
| AG | 0.240 | 0.280 | | 0.260 | 0.260 | 0.260 | 0.260 | | |
| AH | 0.240 | 0.260 | | 0.244 | 0.244 | 0.2445 | 0.244 | | |
| AI | 2.000 | 2.020 | | 2.0025 | 2.003 | 2.0025 | 2.0035 | | |
| AJ | 0.023 | 0.043 | | 0.033 | 0.033 | 0.033 | 0.033 | | |
| Accept/Reject | | | | | | | | | |

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|--------------|----------|
| Measured by: | DTP |
| Date: | 10/09/06 |

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|-------------|----------|
| Audited by: | SL |
| Date: | 12/09/15 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

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|--|---------------------------|
| DART AEROSPACE LTD | Work Order: 61332 |
| Description: Saddle, Fwd Outboard | Part Number: D2571 |
| Inspection Dwg: D2571 Rev. E | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

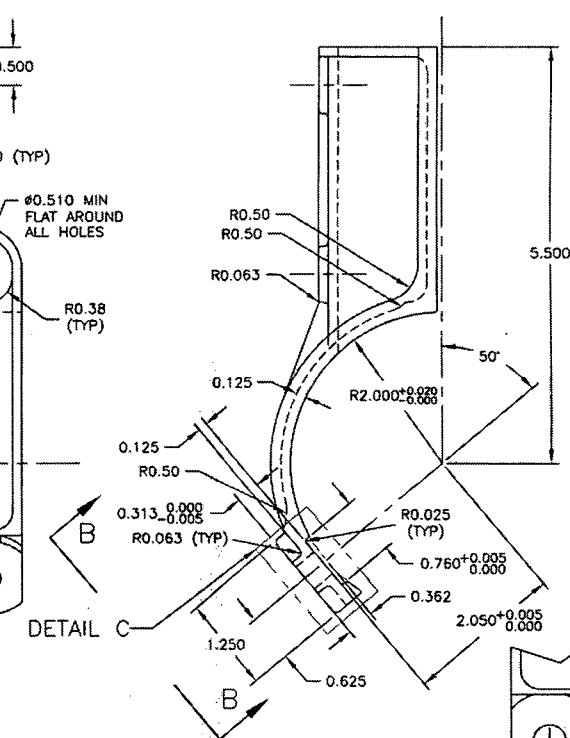
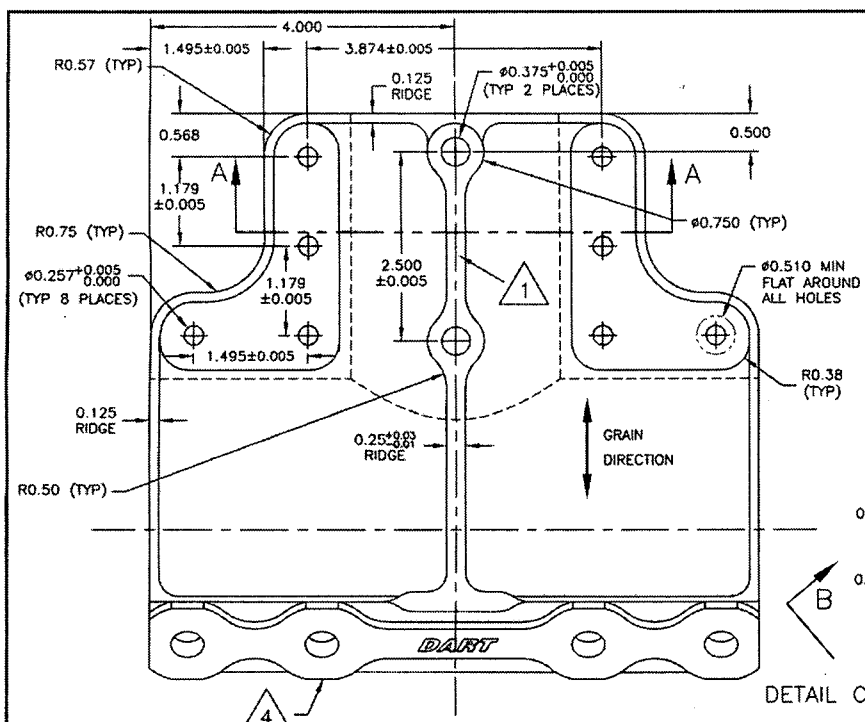
| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 9 | 10 | 11 | 12 | By | Date |
| A | 0.438 | 0.443 | | 0.442 | 0.442 | 0.442 | 0.442 | | |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| E | 7.990 | 8.010 | | 8.000 | 8.000 | 8.000 | 8.000 | | |
| F | 0.490 | 0.510 | | 0.500 | 0.500 | 0.499 | 0. | | |
| G | 0.257 | 0.262 | | 0.259 | 0.259 | 0.259 | 0.259 | | |
| H | 0.375 | 0.380 | | 0.378 | 0.378 | 0.378 | 0.378 | | |
| I | 0.490 | 0.510 | | 0.496 | 0.498 | 0.496 | 0.497 | | |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| K | 0.558 | 0.578 | | 0.564 | 0.564 | 0.564 | 0.565 | | |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| M | 1.490 | 1.500 | | 1.495 | 1.495 | 1.495 | 1.495 | | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| O | 3.869 | 3.879 | | 3.874 | 3.874 | 3.874 | 3.874 | | |
| P | 0.115 | 0.135 | | 0.125 | 0.124 | 0.124 | 0.124 | | |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| R | 0.240 | 0.260 | | 0.253 | 0.252 | 0.252 | 0.252 | | |
| S | 0.115 | 0.135 | | 0.131 | 0.133 | 0.131 | 0.133 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| U | 2.940 | 2.980 | | 2.960 | 2.960 | 2.960 | 2.960 | | |
| V | 0.230 | 0.250 | | 0.233 | 0.234 | 0.234 | 0.234 | | |
| W | 0.115 | 0.135 | | 0.124 | 0.126 | 0.126 | 0.126 | | |
| X | 0.308 | 0.313 | | 0.311 | 0.311 | 0.311 | 0.311 | | |
| Y | 0.760 | 0.765 | | 0.762 | 0.762 | 0.762 | 0.762 | | |
| Z | 0.352 | 0.372 | | 0.364 | 0.363 | 0.363 | 0.363 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.627 | 0.627 | 0.627 | 0.627 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AD | 0.240 | 0.260 | | 0.250 | 0.255 | 0.255 | 0.255 | | |
| AE | 1.375 | 1.395 | | 1.394 | 1.392 | 1.390 | 1.395 | | |
| AF | 0.115 | 0.135 | | 0.125 | 0.125 | 0.125 | 0.125 | | |
| AG | 0.240 | 0.280 | | 0.260 | 0.260 | 0.260 | 0.260 | | |
| AH | 0.240 | 0.260 | | 0.244 | 0.246 | 0.245 | 0.245 | | |
| AI | 2.000 | 2.020 | | 2.004 | 2.004 | 2.002 | 2.003 | | |
| AJ | 0.023 | 0.043 | | 0.033 | 0.033 | 0.033 | 0.033 | | |
| Accept/Reject | | | | | | | | | |

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|-------------------------|
| Measured by: <i>DTJ</i> |
| Date: 10/09/14 |

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|-----------------------|
| Audited by: <i>85</i> |
| Date: 10/09/15 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

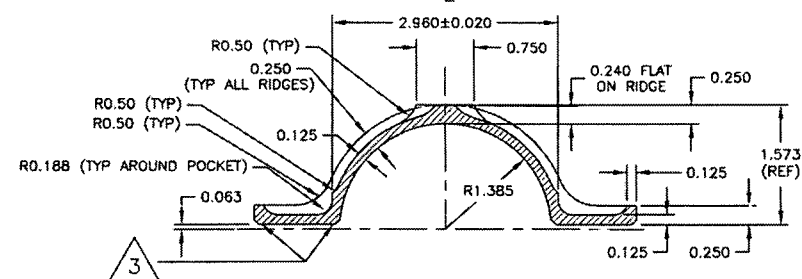
RELEASED
05.12.06



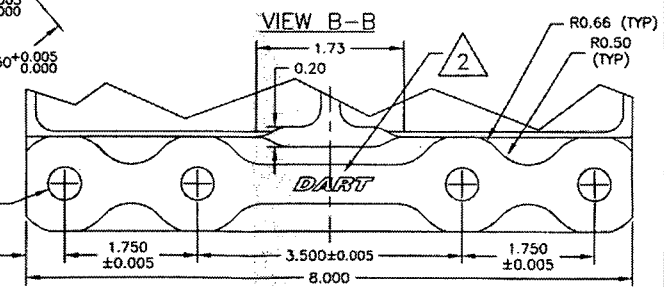
NOTES

MATERIAL: 7075-T7351 (00-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

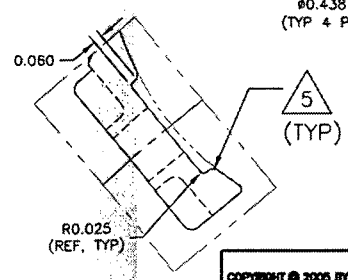
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)



SECTION A-A



| | | |
|---|----------|---|
| E | 05.07.13 | ADD CHAMFER ON RIDGE, NOTE 5 |
| D | 02.09.06 | ADD RIDGES; TIGHTEN TOLERANCES |
| C | 99.10.22 | INCCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177 |
| B | 96.12.02 | ADD GRAIN DIR., 0.438 WAS 0.425 |
| A | 96.09.16 | NEW ISSUE |



DETAIL C
SCALE 4:3

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|---------|----------|----------|------------------|-------------|--|
| DESIGN | DS | DRAWN BY | PH | DART | DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA |
| CHECKED | # | APPROVED | # | DRAWING NO. | 02571 |
| DATE | 05.07.13 | TITLE | OUTER FWD SADDLE | REV. E | SHEET 1 OF 1 |
| | | SCALE | 2:3 | | |

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